

Work Order ID 139970

December 15, 2015 4:06:05 PM

rush.
139970

Page 1

Item ID: D3535-35

Accept

Qty 1 to ship Dec 17/15
N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Aft

Start Date: 12/15/2015 Start Qty: 12.00

12

Cust Item ID:

Required Date: 12/17/2015 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: *SA*

Date: **20151215**

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3535	Rev B

100	FLOW WATER JET	0.01
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100

Waterjet

Memo

0.03

FLOW CNC Waterjet

1-Cut as per Dwg D3535 Dwg Rev: *B* Prog Rev: *B* 2-
Deburr if necessary

18 *15/12/17*

110	QC2- Inspect parts off machine FAI/FAIB	0.00
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110

QC

Memo

0.00

Quality Control

18 *15/12/17*

120	QC8- Inspect parts - second check	0.00
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120

QC

Memo

0.00

Quality Control

DAS
16
9-89

18 *2015/12/18*

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Item ID: D3535-35 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Aft
 Start Date: 12/15/2015 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 12/17/2015 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo 1-Deburr if necessary2-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326.3-Identify as D3535-35.	0.00 0.00			DAS 30 9-89	18			DEC 18 2015
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(18)	15-12-18		DAS 9 9-89
150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>m 130716</i> Memo START TIME: <u>10:15</u> OVEN TEMPERATURE: <u>320</u> FINISH TIME: <u>10:45</u>	0.00 0.00				18	15-12-21		DAS 9 9-89

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Item ID: D3535-35 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Aft
 Start Date: 12/15/2015 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 12/17/2015 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							DAS 9 9-89
Quality Control									

170	Identify as per dwg & Stock Location: <u>FP-002</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging	LOCATION : FP002								

x 18 of all 1512/21

180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.02							
Quality Control									

MCS DEC 21 2015

AS-21

Picklist Print

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Work Order ID: 139970

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Parent Item: D3535-35

D3535-35

Parent Item Name: Wearplate Aft

Start Date: 12/15/2015

Required Date: 12/17/2015

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	96.0000	0.8022	10.13305			

M304S20GA

304/316 .040 Sheet

**

EL 15-12-17

Location

Loc Qty

Loc Code

MAT020

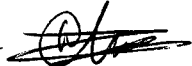
96

m133511

96

M 304 S20GA 4P

127/46 x 12.3"

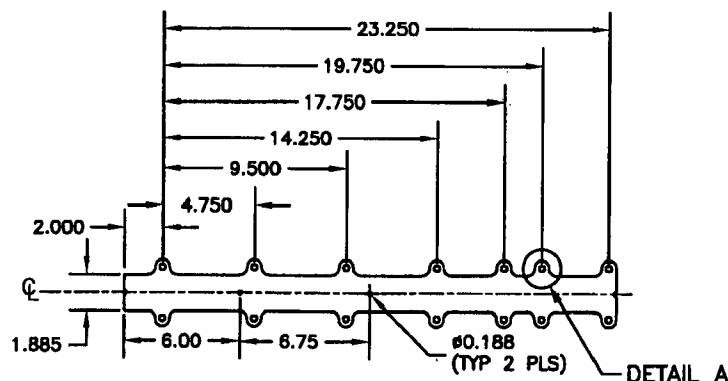
Acceptable for use 

15-12-21



RELEASED
07.04.24

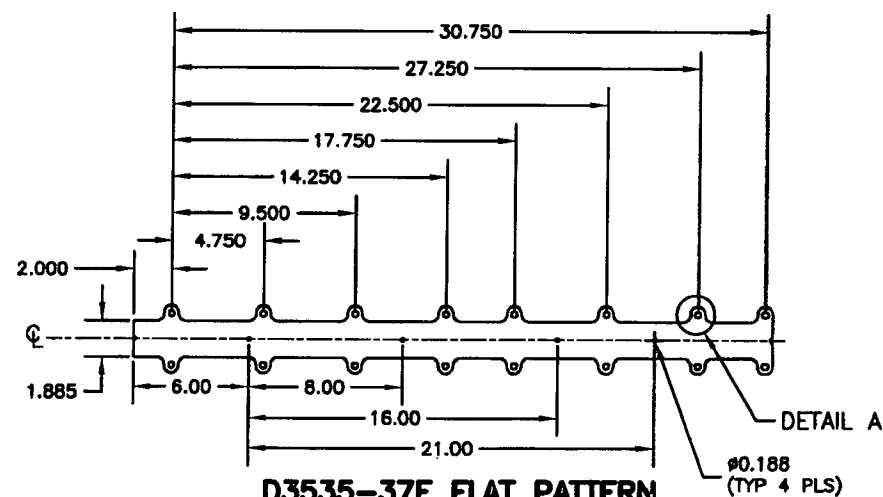
DESIGN	C B	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 5 OF 7
		SCALE	1:10	



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

20151215

SH 139970

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DART AEROSPACE LTD		Work Order:	139970
Description: Wearshoe		Part Number:	D3535-35
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2.00	✓		U-DC02	
1.885	+/-0.010	1.891	✓			
6.00	+/-0.030	6.0	✓			
6.75	+/-0.030	6.75	✓			
Ø0.188	+0.005/-0.001	0.170	✓			
23.250	+/-0.010	23.250	✓			
19.750	+/-0.010	19.750	✓			
17.750	+/-0.010	17.750	✓			
14.250	+/-0.010	14.25	✓			
9.500	+/-0.010	9.5	✓			
4.750	+/-0.010	4.750	✓			
0.300	+/-0.010	0.304	✓			
0.300	+/-0.010	0.304	✓			
0.038	+/-0.010	0.034	✓			

Measured by:	AL	Audited by:	DAS 16	Prototype Approval:	N/A
Date:	15-12-17	Date:	9-89 15/12/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	BE